

19-7794



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-351
Job Sheet 201544



Part No: D206-642-351

Job Qty: 1 pcs

Part Name: Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4361-041 REV A, IIN-D206-642 REV Q SHEETS 29-30 IPP REV:A NEW ISSUE 12-07-09 JLM
VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/30/19		0.00	3.26	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		TF BE
							Skidtubes - 6		
							Skidtubes - 7		
112	QC 9	1 pcs	10/30/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		FL
115	QC 5	1 pcs	10/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		



Container No: S228384



Part: D206-642-351

Job No: 201544

Serial No/Batch: S228384

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/30/19

Plex 10/7/19 10:31 AM Dart.lajeunesse.marie

P.T.O.

120 Handfinish - 1-1 Chemical-B4B	1 pcs	10/30/19	0.00 0.83	QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 31 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
125 QC 7	1 pcs	10/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	

					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MGC
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
130 Skidtubes - 2 - B4B	1 pcs	10/30/19	0.00 3.26 1:39.45 TF	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B	TF	
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
140 QC 5	1 pcs	10/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18	BE	
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
150 Skidtubes - 2 - B4B	1 pcs	10/30/19	0.00 3.26 3:42.16 TF 2:41.16	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B	BE	
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
170 QC 10	1 pcs	10/30/19	0.00 0.00	QC 10 - 10		
				QC 10 - 18		
				QC 10 - 24		
				QC 10 - 43		
				QC 10 - 50		
				QC 10 - 58		
				QC 10 - 9		
				QC 10 - 68		
180 QC 5	1 pcs	10/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
					DAS NOV 05 2019 68 9-89	
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				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
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				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	NOV 05 2019
				QC 5 - 9	DAS 68
				QC 5 - 50	9-89
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190	Handfinish - 2-1 Pressure-B4B	1 pcs	10/30/19	0.00 0.50	Handfinish - 2 - 1 - B4B
					Handfinish - 2 - 2 - B4B
					Handfinish - 2 - 3 - B4B
					Handfinish - 2 - 4 - B4B
200	Powdercoat - 1 White Gl(A)-B4B	1 pcs	10/30/19	0.00 0.23	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
210	QC 3	1 pcs	10/30/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
220	Handfinish - 4-1-Assembly-B4B	1 pcs	10/30/19	0.00 0.83	Handfinish - 4 - 1 - B4B
					Handfinish - 4 - 10 - B4B
					Handfinish - 4 - 11 - B4B
					Handfinish - 4 - 12 - B4B
					Handfinish - 4 - 13 - B4B

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					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
230	QC 3	1 pcs	10/30/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
240	QC 5	1 pcs	10/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
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					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	

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250	Packaging 3-1 - Stock - B4B	1 pcs	10/30/19	0.00 0.00	QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
255	DC - 1 - B4B	1 pcs	10/30/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
260	QC 21 - FG	1 pcs	10/30/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

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Part Op 110 - Skid tubes-2 (Skid tubes) 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D4361 3-Weld Fwd Cap as per Dwg D4361 Use aluminum rod. Grind D2647 to fit as required. 5-Cut aft end to length as per Dwg D4361 6-Drill pilot holes using drill Jig DT8168A and DT8168B and DT8025. Most Fwd wearplate hole to be laid out manually. 8-Open Aft Cap Hole using # Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-041 Drilling Detail 10-Remove inner indexing ridge on aft end of skid tubes as per Dwg D4361 11-Deburr and Blow out all chips form inside the tube

115 - QC5 (QC5- Inspect part completeness to step on W/O)

120 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

125 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

130 - Skid tubes-2 (Skid tubes) 1-Open holes to finished size as per Dwg D4361, D4361-041 Drilling Detail 2-Countersink crossbolt spacer holes as per Dwg D4361 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-5 web in place as per QSI 015, Ensure holes line up. Allow 12 Hrs. cure time

140 - QC5 (QC5- Inspect part completeness to step on W/O)

150 - Skid tubes-2 (Skid tubes) 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 2-Grind welds flush as per Dwg D4361. 3-Counterbore 5/16" x 0.750" deep as per Dwg D4361. Deburr 4- Install nut plate as per Dwg

170 - QC10 (QC10- Inspect visual per QSI004- ground welds)

180 - QC5 (QC5- Inspect part completeness to step on W/O)

190 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings)AND ALODINE ONLY AS PER QSI005

200 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint

screw, and mask GHW studs.

210 - QC3 (QC3- Inspect Part Finish)**220** - HandFinish4 (Assemble as per dwg) 1-Install wearplates as per dwg D4361. 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D4361. Clean excess adhesive 6-Wing Walk as per Dwg D4361-041 and QSI 005 4.4**230** - QC3 (QC3- Inspect Part Finish)**240** - QC5 (QC5- Inspect part completeness to step on W/O)**250** - Packaging3-1 (Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-351**255** - DC (Document Control) Photocopy bluefile and create labels per PPP D206-642-351 CHG001**260** - QC21 (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	012839
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5210317
D2654-5	Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B	5166098
D2649	Cross Bolt Spacer	23 pcs (23 ea)	150-Skidtubes - 2 - B4B	522049
AN3-36A	Bolt	9 Ea (9 ea)	220-Handfinish - 4-1-Assembly-B4B	5335932
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5094573
CR3212-4-3	Cherry Rivet	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5163230-3
D2646	Aft Cap	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5197616
D2651-1	Plug	4 pcs (4 ea)	220-Handfinish - 4-1-Assembly-B4B	519604d
D2651-3	O-Ring	4 pcs (4 ea)	220-Handfinish - 4-1-Assembly-B4B	5180320
D2680-041	Nut Plate	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5197646
D3873-1	Bushing	18 pcs (18 ea)	220-Handfinish - 4-1-Assembly-B4B	5215044
D4364-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5229377
D4364-043	Run-on Landing Wearplate Aft	1 pcs (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5229112
MS21042-3	Nut use MS21042L3 per QSI 017	9 Ea (9 ea)	220-Handfinish - 4-1-Assembly-B4B	5049569
MS27039-1-08	Screw	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5162897
MS27039-4-06	Screw	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5168743
NAS1149C0332R	Washer (AN960C10L)	9 Ea (9 ea)	220-Handfinish - 4-1-Assembly-B4B	5218156
NAS1149D0332J	Washer	2 Ea (2 ea)	220-Handfinish - 4-1-Assembly-B4B	5178378
NAS1149D0463J	Washer	1 Ea (1 ea)	220-Handfinish - 4-1-Assembly-B4B	5120802
				5219142

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	15	0
	D2647	1	20	0
130-Skidtubes - 2 - B4B	D2654-5	1	8	0
150-Skidtubes - 2 - B4B	D2649	23	51	0
220-Handfinish - 4-1-Assembly-B4B	AN3-36A	9	50	0
	CCR264SS3-3	2	43	0
	CR3212-4-3	2	232	0
	D2646	1	46	0
	D2651-1	4	205	0
	D2651-3	4	609	0
	D2680-041	1	21	0
	D3873-1	18	83	0
	D4364-041	1	0	0
	D4364-043	1	0	0
	MS21042-3	9	455	0
	MS27039-1-08	2	186	0
	MS27039-4-06	1	228	0
	NAS1149C0332R	9	4,028	0
	NAS1149D0332J	2	1,455	0
	NAS1149D0463J	1	2,589	0

Part Specifications

Specifications could not be found.

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-160	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

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WITHOUT NOTICE
WORK ORDER

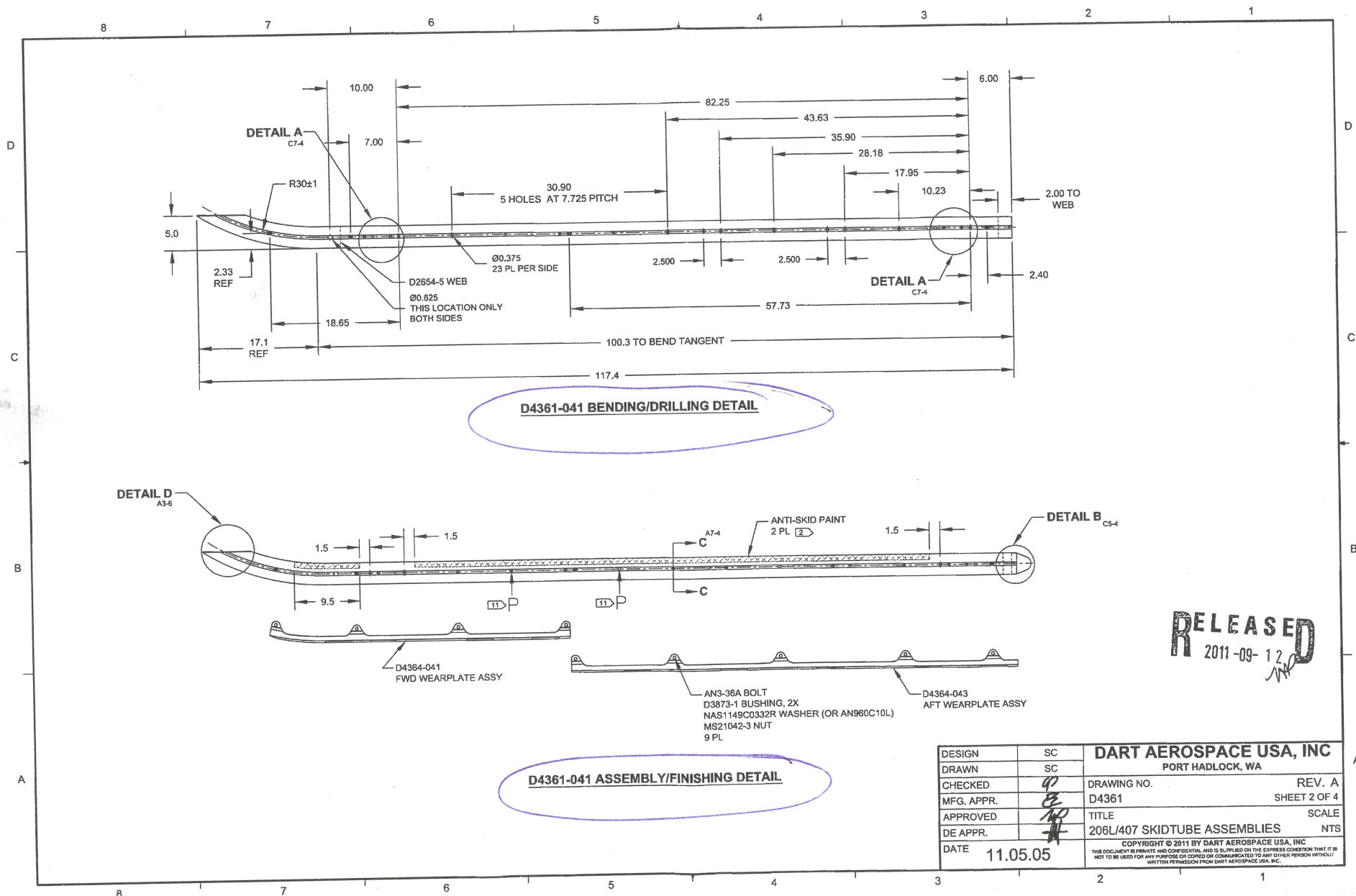
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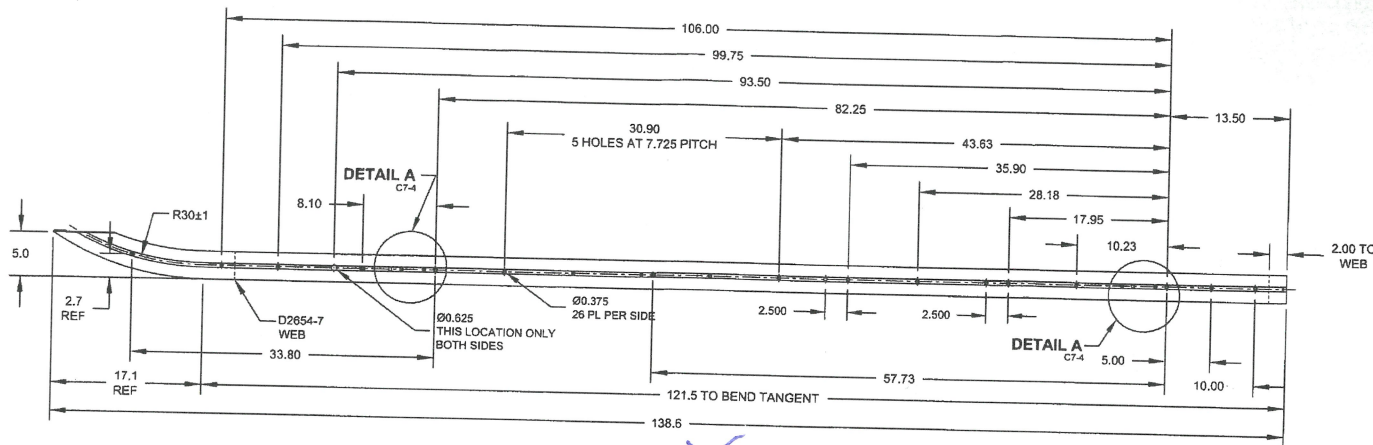
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

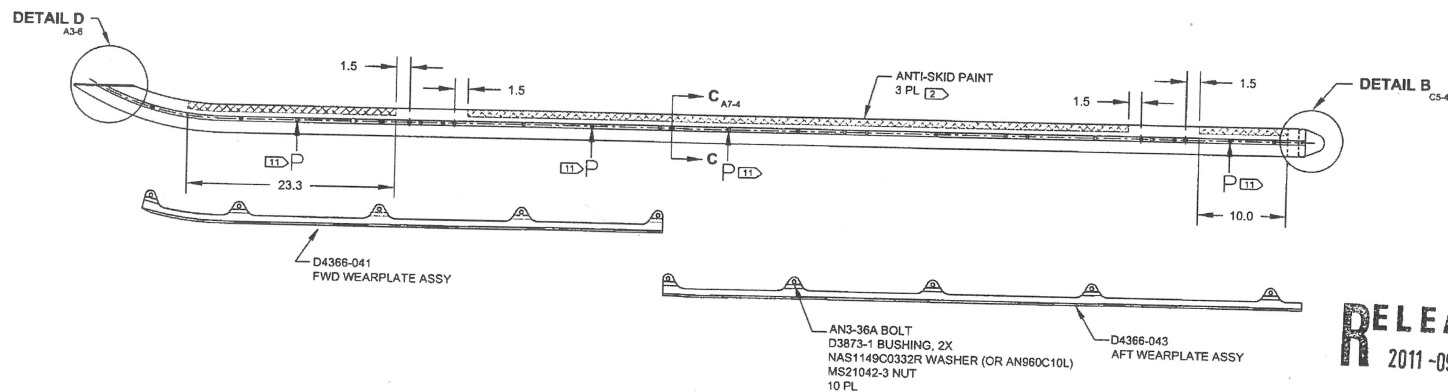
RELEASED
2011-09-12
JWP

A	NEW ISSUE	SC	11.05.05
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DRAWN	SC	PORT HADLOCK, WA	
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	BE	D4361	SHEET 1 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	JH	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





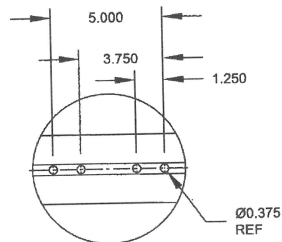
D4361-043 BENDING/DRILL DETAIL



D4361-043 ASSEMBLY/FINISHING DETAIL

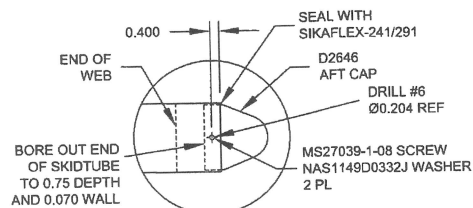
RELEASED
2011-09-12

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4361	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L/407 SKIDTUBE ASSEMBLIES	NTS
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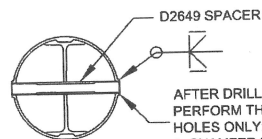
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

B2-2
B1-3

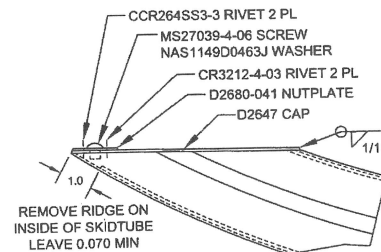


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

SECTION C-C
FOR Ø0.375 HOLES
ONLY

B4-2
B5-3

ORIENTATION OF
D2680-041



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4361	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: LRDate: Dec 9/19NCR No. 19-7794

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>201544</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D206-642-357</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐
Date: <u>19/10/30</u>	Sequence #: <u>120 110</u>		QTY Affected: <u>①</u>		MRB (QSI042) <u>INS</u> <u>12</u> <u>19/10/30</u>		
Description Work Order Deviation			Disposition			Completed By	
Dwg calls for $\phi 0.625$ tow ring hole which is too small for tow ring			Drill tow ring hole $\phi 0.640$ Ref. D3274 Rev. G			TF	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Root Cause			FAULT CATEGORY				
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			☒ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details:							